Amendments to the Specification:

Page 2, delete both diagrams, including legends and labeling (numbered lines 5-11 and 14-22).

Page 3, second full paragraph, replace with:

The absorptive characteristics of the ply material also have a significant impact on the adhesive performance when aqueous adhesives are used. If the ply material is too absorbent, the adhesive penetrates the ply material and precures (becomes dry) before the ply is wound on the mandrel. If the ply material is made of ~~an~~ a nonabsorbent material, the coated ply is likely to be too wet when it comes in contact with another ply, thus causing slippage.

Page 4, delete the last 3 paragraphs (lines 7-24).

Page 5, before "DETAILED DESCRIPTION OF THE INVENTION" (at line 7) insert the following:

BRIEF DESCRIPTION OF THE DRAWING FIGURES

Figure 1 is a diagram of a typical convolute can winder.

Figure 2 is a diagram of a spiral winder.

Page 5, following "DETAILED DESCRIPTION OF THE INVENTION" (between lines 8 and 9) insert the following:

It has been found, in accordance with the present invention, that introduction of foam into adhesives formulated for paper cores or tubes, overcomes some of the problems discussed above. Introduction of foam into the adhesive widens the adhesive operating window and improves the efficiency of the core making process.

Specifically, foamed adhesives do not penetrate porous surfaces to the same extent as nonfoamed adhesives and therefore open time increases and the tendency to precure decreases. In addition, in any given film thickness, a foamed adhesive contains less water than an unfoamed adhesive. With less water to dissipate, a bond forms more quickly upon compression reducing the possibility of ply slippage and/or "dog ears". Also, the possibility of producing soft and/or soggy cores or tubes is reduced.

The foamed adhesives of the present invention allow tube/core manufacturers to use less adhesive and therefore add less moisture to the core construction. The reduced adhesive content per a given volume allows high speeds to be obtained without adjustments to application amount. In addition, at slow speeds, these adhesives will not permeate the surface of a substrate, therefore allowing acceptable core/tube production.

Page 5, between lines 12 and 13 insert the following:

Conventional convolute winding, illustrated diagrammatically in Fig. 1, uses a web of paper that is as wide as the resulting core is long. A mandrel spins and winds the

paper onto itself forming the core. The adhesive is continuously applied to the ply material as the core is wound.

Spiral winding, illustrated diagrammatically in Fig. 2, comprises continuous winding of 2 or more plies around a mandrel at an angle causing the length of the core to grow as the plies are wound. The adhesive is continuously applied to the ply material as the core or tube is wound.

New, substitute, drawing Figure 1 and drawing Figure 2 is submitted herewith on separate pages.